

Work Order ID 103851

103851

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July-03-13 9:27:52 AM

Item ID: D2565-209

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Strut

Start Date: 7/03/13

Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/16/13

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2565

Rev E

100

0.00

100

Brake NC

NC BRAKE

Memo

0.00

Brake NC

Punch as per DWG D2565 using DT 8313

110

0.00

110

Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr

120

0.00

120

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

SB 3/07/04

EP 13/08/15

SW 13.8.15

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N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Strut

Start Date: 7/03/13

Start Qty: 6.00

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Cust Item ID:

Required Date: 7/16/13

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6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

130

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3-45
400°F
4:15

6x4 m/f 13/08/15

140

QC3- Inspect Part Finish

0.00

140

QC

Quality Control

Memo

0.00

6x d 13/08/16

150

Identify as per dwg & Stock Location: ST253A

150

Packaging

Packaging

Memo

0.00

6x m/f 13-08-16

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July-03-13 9:27:52 AM

Item ID: D2565-209 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut

Start Date: 7/03/13 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 7/16/13 Req'd Qty: 6.00 ***6*** Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MCS 13-08-21
QC 13-8-19

Picklist Print

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Work Order ID: 103851

Parent Item: D2565-209

Parent Item Name: Strut

Start Date: 7/03/13

Required Date: 7/16/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: D01.06.04Added Powder Coat, Removed Polish, and Added Inspection Levels 3 & 2IEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	838.2989	1.2833	8.1050526			
304 RD Tube .750 x .049W													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT017	838.2988825	
122312	13.3	
122468	0.0000325	
124768	83.93245	
125068	52.0664	
125513	289	
M126183	400	

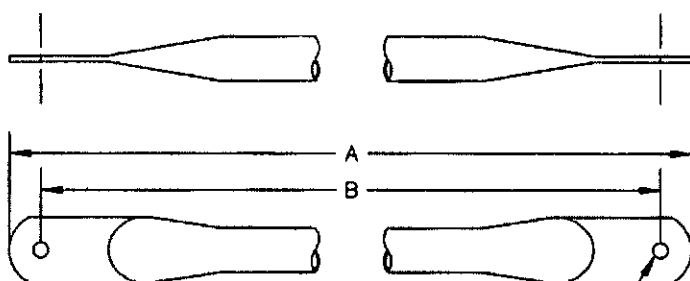
9.5

SP-12/07/13



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT SCALE 1:3	
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
04.05.05



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY
PUNCH ENDS PER SPEC CONTROL DRAWING D2638

103851

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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